

Work Order ID 122815

\*122815\*

Page 1

Item ID: D4893-2

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Hard Point Adapter, RH

Start Date: 7/28/14 Start Qty: 2.00 \*2\*

Cust Item ID:

Required Date: 8/08/14 Req'd Qty: 2.00 \*2\*

Customer:

Reference:

Approvals: Process Plan: W Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D4893	A								
100	BAND SAW	0.00				2	0		MH
<b>*100*</b>									
Bandsaw	<b>Memo</b>	0.00							14/07/29
Jeaspa Bandsaw	Cut blank:3.375" long								
110	HAAS CNC VERTICAL MACHINING #1	0.00							
<b>*110*</b>						2	1		MSP. 14/08/01
HAAS 1	<b>Memo</b>	0.00							
HAAS CNC vertical machine #1	1- Machine as per Folio FB193 and Dwg D4893								
	FOLIO REV: <u>AA</u>								
	DWG REV: <u>A</u>								
	DEBURR								

P103





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**Accept**

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 7/28/14      **Start Qty:** 2.00      **\*2\***

**Cust Item ID:**

**Required Date:** 8/08/14      **Req'd Qty:** 2.00      **\*~\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:**      **Tooling:**      **Date:**

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Stop** **\*NR2\***

Sequence ID/  
Work Center ID

### Operation Description

### Set Up/ Run Hours

**Tool ID**

**Tool #****Plan  
Code**

**Accept  
Qty**

Reject  
QtyReject  
Number

**Insp.  
Stamp**

150

QC7-Inspect Chemical Conversion Coat

0.00

**\*150\***

QC

## Memo

0.00

## Quality Control

151

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*151\***

Powdercoat

## Memo

0.00

## Powder Coating

MASK AS PER NOTE 9

155

### QC3- Inspect Part Finish

0.00

**\*155\***

QC

## Memo

0.00

## Quality Control

# Work Order ID 122815

**\*122815\***

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Item ID: D4893-2 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Hard Point Adapter, RH  
 Start Date: 7/28/14 Start Qty: 2.00 **\*2\*** Cust Item ID:  
 Required Date: 8/08/14 Req'd Qty: 2.00 **\*2\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>ST535</u>	0.00							
<b>*170*</b>									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

2x DAS 28 9-89 AUG 14 2014  
 MLD 14-08-15  
 4-85

# Picklist Print

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Page 1

Work Order ID: 122815

\*122815\*

Parent Item: D4893-2

\*D4893-2\*

Parent Item Name: Hard Point Adapter, RH

Start Date: 7/28/14

Required Date: 8/08/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 13-05-27 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X05.00 0		Purchased	No				f	3.0750		1			

\*M6061T6B2 000X05 000\*

6061T6 Bar 2.00 x 5.000

\*\*

Location	Loc Qty	Loc Code
MAT007	3.075	
m128980	3.075	

m126160

.6

MH  
14/07/29

~~X~~

could not pull mat.

M 128573

\* Mat not pulled!

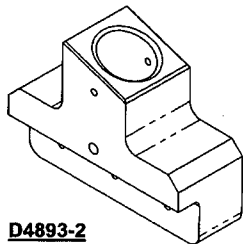
14/08/01 0,416

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 122815
<b>Description:</b> Hardpoint Adapter, RH		<b>Part Number:</b> D4893-2
<b>Inspection Dwg:</b> D4893	<b>Rev:</b> A	<b>Page 1 of 1</b>

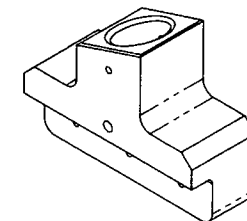
### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
72°	+/-0.5°	72°	✓		MIP-04	vern
1.50	+/-0.030	1.500	✓		...	...
0.03 x 45°	+/-0.030 x +/-0.5°	0.030	✓		↓	↓
2.45	+/-0.030	2.450	✓		↓	↓
1.30	+/-0.030	1.302	✓		31006	Height gauge
0.75	+/-0.030	0.753	✓		MIP-04	vern
2.500	+/-0.005	2.500	✓		↓	↓
1.250	+/-0.005	1.250	✓		↓	↓
R0.25	+/-0.030	0.250	✓		—	Radius gauge
0.50	+/-0.030	0.501	✓		MIP-04	vern
Ø0.129	+0.005/-0.001	0.130	✓		...	...
Ø0.204	+0.005/-0.001	0.205	✓		↓	↓
1.50	+/-0.030	1.503	✓		↓	↓
1.00	+/-0.030	1.000	✓		MIP-08	<del>g</del> Dial depth gauge
1.00	+/-0.030	1.000	✓		MIP-04	vern
R0.13	+/-0.030	0.130	✓		—	Radius gauge
0.83	+/-0.030	0.830	✓		MIP-04	vern
0.10 x 45°	+/-0.030 x +/-0.5°	0.100	✓		...	...
1.75	+/-0.030	1.750	✓		MIP-08	Dial depth gauge
1.46	+/-0.030	1.465	✓		31006	Height gauge
1.65	+/-0.030	1.653	✓		MIP-04	vern
4.00	+/-0.030	4.002	✓		...	...
0.25 x 45°	+/-0.030 x +/-0.5°	0.250 x 45°	✓		...	...
0.750	+/-0.010	0.751	✓		31006	Height gauge
Ø1.015	+0.002/-0.001	1.015	✓		MIP-04	vern

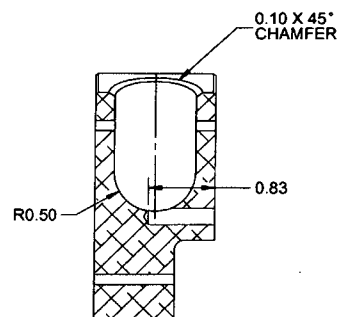
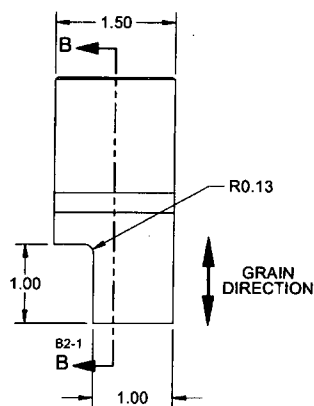
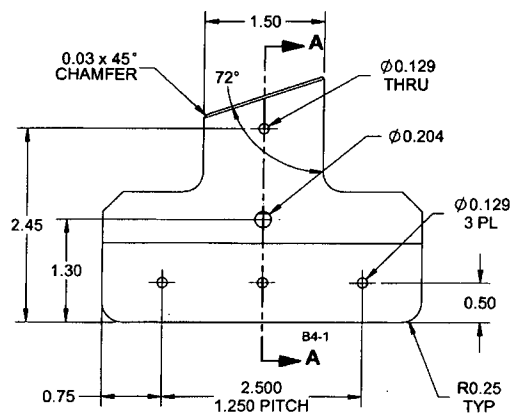
<b>Measured by:</b> <i>W.D.</i>	<b>Audited by:</b> <i>D.A.</i>	<b>DAS</b> 08	<b>Preliminary Approval:</b>
<b>Date:</b> 14/08/01	<b>Date:</b> 14/08/01	<b>9-89</b>	<b>Date:</b>
<b>Rev</b> A	<b>Date</b> 14.07.09	<b>Change</b> New Issue	<b>Revised by</b> <i>KJ</i> <b>Approved</b> <i>[Signature]</i>



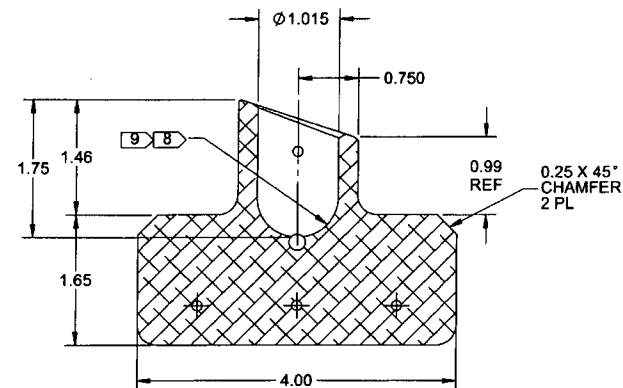
**D4893-2**



**D4893-1**



**SECTION A-A B7-1**



**SECTION B-B B6-1**

**D4893-1 HARDPOINT ADAPTER, LH**  
**D4893-2 HARDPOINT ADAPTER, RH OPPOSITE**

**NOTES:**

- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR  
 PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
 OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
 OR ASTM B211 OR ASTM B221  
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.92 lbs
- 8) SURFACE FINISH 80-125 uin. IN THE BOTTOM OF THE Ø1.015 BORE IS ACCEPTABLE
- 9) MASK Ø1.015 BORING HOLE PRIOR TO POWDER COAT

*w/10 22815*

**RELEASED**  
 2013-06-12  
*W*

A NEW ISSUE		RF		13.05.24
REV.		DESCRIPTION		DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED	<i>[Signature]</i>	DRAWING NO.		REV. A
MFG. APPR.	<i>[Signature]</i>	<b>D4893</b>		SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE		SCALE
DE APPR.	<i>[Signature]</i>	<b>HARDPOINT ADAPTER</b>		NTS
DATE	13.05.24	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		